

	Product Specification RQ 235/245 for Lamp and General Application	SPEC_Z_LW_08 (Rev.1) page 1 of 9
Authors: 28.09.2009 Ludwig Stier Dr. Sigrun Rakus	Approved: 28.09.2009 Frithjof Raesch	Released: 28.09.2009 Frithjof Raesch

Introduction:

Types **RQ 235** and **RQ 245** are clear machine-drawn quartz tubing products doped with TiO₂.

The transmittance of RQ 235 is cut off at app. 215 nm (at 20 °C).

The transmittance of RQ 245 is cut off at app. 230 nm (at 20 °C).

Main application areas of **RQ 235** are manufacturing of high pressure discharge lamps for sun tanning lamps, low pressure germicidal lamps and ozone-free reprographic lamps.

Main application areas of **RQ 245** are manufacturing of sun tanning lamps and ozone-free reprographic lamps.

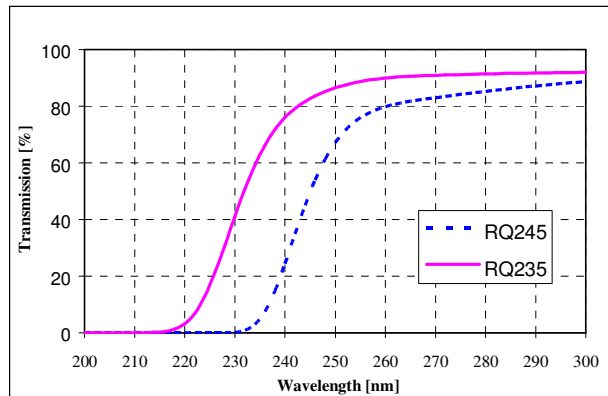
Physical Properties:

		RQ 235	RQ 245
Linear thermal expansion coefficient (20 – 320) °C	[10 ⁻⁶ K ⁻¹]	0.58	0.58
Modulus of Elasticity	[GPa]	73	73
Poison's Ratio	[1]	0.17	0.17
Density	[gcm ⁻³]	2.2	2.2
Transformation temperature	[°C]	1150	1150
Viscosity	[dPas]	[°C]	[°C]
	10 ^{14.7} Strain point	1160	1250
	10 ^{13.2} Annealing point	1250	1320
	10 ^{7.6} Softening point	1700	1740
	10 ⁴ Working point	2270	2370
Maximum working temperature	[°C]	900	950
Electrical resistance	[Ω cm]	[°C]	[°C]
	10 ⁴	1660	1660
	10 ⁶	1000	1000
	10 ⁸	510	510
Dielectric constant at 20 °C, 1 MHz	[1]	3.7	3.7
Dielectric loss factor at 20 °C, 1 MHz	[10 ⁻⁴]	< 2	< 2
Refractive index at λ = 587.6 nm	[1]	1.459	1.459
Thermal conductivity at 20 °C	[Wm ⁻¹ K ⁻¹]	1.4	1.4

	Product Specification RQ 235/245 for Lamp and General Application	SPEC_Z_LW_08 (Rev.1) page 2 of 9
	Authors: 28.09.2009 Ludwig Stier Dr. Sigrun Rakus	Approved: 28.09.2009 Frithjof Raesch

Transmission Properties:

Transmission Curves RQ 235/245



RQ 235 Limits for Transmission Values at 1.00 [mm] wall thickness:

Wave length λ [nm]	205	220	230	240	254	300	350
Transmission T [%]	< 3	< 20	40 < T < 65	T > 75	> 85	T > 89	T > 90

RQ 245 Limits for Transmission Values at 1.00 [mm] wall thickness:

Wave length λ [nm]	230	240	260	290	370
Transmission T [%]	< 2	32 < T < 38	75 < T < 85	> 85	> 90

Chemical Composition:

SiO₂ [%] app. 99.96 (RQ 235) app. 99.88 (RQ 245)

Typical trace elements [ppm] in **RQ 235 / RQ 245:**

Al	15	Li	0.7
B	< 1	Mg	0.1
Ca	0.6	Na	0.7
Fe	0.3	Zr	< 1
K	< 1		

For the OH- content the following description and values need to apply:

RQ 235/245	unbaked	ca. 120 - 150 ppm
RQ 235/245 V4	vakuum baked	< 5 ppm
RQ 235 V40	vakuum baked	≤ 1 ppm
RQ 245 V40	vakuum baked	< 4 ppm

	Product Specification RQ 235/245 for Lamp and General Application	SPEC_Z_LW_08 (Rev.1) page 3 of 9
Authors: 28.09.2009 Ludwig Stier Dr. Sigrun Rakus	Approved: 28.09.2009 Frithjof Raesch	Released: 28.09.2009 Frithjof Raesch

Visual Characteristics:

Standard Inspection Lighting:

The term “visible” is used for flaws (typically > 0.25 mm) that can be seen under general overhead inspection illumination. The light source is typically 0.75 – 1.25 m above the piece, with the tubing viewed at a distance of 0.3 – 0.6 m from the inspector, with a white/black background.

Airlines

A: Airline (enclosed):

Definition:

A void, wholly within the tube wall including those bumping up the surface.

Limits:

Size	Total Cumulative Length of Airlines per Piece	Maximum Airline Width
Up to 15.0 mm OD	12 %	0.15 mm
15.1 mm OD to 25.0 mm OD	12 %	0.25 mm
25.1 mm OD to 30.0 mm OD	12 %	0.30 mm
30.1 mm OD to 40.0 mm OD	12 %	0.40 mm
40.1 mm OD to 50.0 mm OD	12 %	0.70 mm
50.1 mm OD to 60.0 mm OD	12 %	1.00 mm

Customer specified tubes may have requirements for less than 12 % total airlines and smaller airline width. We offer 2 additional air line classes: class 10 and class 6 with 10 % respective 6 % total cumulative length of airlines per piece.

B: Open ID or OD Airline:

Definition:

A void, open to the ID or OD surface, which has sharp, knifelike edges.

Limits:

None permitted (above visual detection of 0.1 mm width).

C: “Bumpy” ID or OD Airline:

Definition:

A raised area in the wall of the tubing, directly over an enclosed void near the surface, on the ID or OD.

Limits:

10 % maximum total cumulative length of airlines per piece, except none so thin as to open with the pressure of a gloved fingernail.

None permitted in tubing < 6 mm OD at the OD surface (above visual detection of 0.1 mm width).

	Product Specification RQ 235/245 for Lamp and General Application	SPEC_Z_LW_08 (Rev.1) page 4 of 9
Authors: 28.09.2009 Ludwig Stier Dr. Sigrun Rakus	Approved: 28.09.2009 Frithjof Raesch	Released: 28.09.2009 Frithjof Raesch

Dirty

Definition:

Removable foreign material adhering to the tube surfaces.

Limits:

- None permitted on the ID. Exceptions: A light, uniform degree of cutting quartz dust is permitted at the tube ends. Material designated fc (furnace cut) is permitted a moderate degree of cutting dust on the ID.
- No obvious fingerprints.
- No spot larger than 2.0 mm in diameter or smaller spots adding to 2.0 mm diameter within any 300 mm of length.
- Readily apparent, non-uniform cutting dust on the OD is not permitted. Material designated fc (furnace cut) is permitted a moderate degree of cutting dust on the OD.
- No clearly visible water spot larger than 2.0 mm diameter, or several adding up to more than 2.0 mm equivalent diameter area (3.14 mm²) within 300 length of tubing.
- Readily apparent, non-uniform graphite on the OD is not permitted.

Checks, Cracks and Tears

Definition:

Crack: A thin break line in the wall that extends through part or all of the wall. The line may also be circular as from impact damage. Cracks are readily visible.

Check: Small fracture perpendicular to the circumferential surface, "V" or chevron shaped extending inward.

Tears: Small fractures on the outside surface of the quartz with minor ">" (chevron) shapes or diamond "<>" shapes running along the surface. Fine tears are similar to scratches. Rejectable tears are readily visible and can be felt with a short fingernail.

Limits:

No readily visible Cracks, Checks or Tears under Standard Inspection Lighting.

Scratch

Definition:

A narrow line abrasion of the surface (over 0.3 mm wide).

Limits:

- No scratches adding up to half the tube length in the longitudinal direction.
- No single scratch exceeding 150 mm.
- No scratches on the inside surface.
- No scratches around the tube adding to twice the tube circumference.

Scuffs

Definition:

Relatively broad lines, bands and/or areas of surface abrasion.

Limits:

	Product Specification RQ 235/245 for Lamp and General Application	SPEC_Z_LW_08 (Rev.1) page 5 of 9
Authors: 28.09.2009 Ludwig Stier Dr. Sigrun Rakus	Approved: 28.09.2009 Frithjof Raesch	Released: 28.09.2009 Frithjof Raesch

- Long length (> 300 mm): Readily visible areas adding up to 12.5 mm of length and complete circumference for 300 mm in average.
- Short length (\leq 300 mm): Readily visible areas adding up to 1/20 of the tube length.

Vapour

Definition:

A haze of silica deposited on the tube surface seen when viewed with the unaided eye.

Limits:

- Reject any degree having a colour other than white.
- Reject if more than 10 % of either the ID or OD surface contains the haze.

Discoloration

Definition:

General bulk colour other than "water white" in the body of a quartz tube.

Limits:

Degree of any type is limited by chemical purity limit as specified in "chemical composition".
Note: vacuum baked – slight darkening may occur.

Striations

Definition:

Circumferential surface variations resulting in optical distortions, over the full length of the tube.

A: Standard Striation:

Limits:

- Accept light striations uniformly distributed around either a portion or the full circumference of the tube.
- Alternatively other striation levels can be agreed and documented by means of a customer limit sample.

B: High Quality Striation:

Definition:

High Quality Striation is clear quartz tubing with minimal optical distortions. Originally defined for optical applications. High Quality Striation requires no striations on the ID or OD surfaces that would cause unacceptable shadows in a light beam projecting from the tube ID. High Quality Striation evaluations require a high degree of visual discrimination and are presently made as "best judgement call".

Limits:

- OD or ID bumpy striations are not acceptable.
- Reject striation levels that exceed any customer agreed upon limit samples.

	Product Specification RQ 235/245 for Lamp and General Application	SPEC_Z_LW_08 (Rev.1) page 6 of 9
Authors: 28.09.2009 Ludwig Stier Dr. Sigrun Rakus	Approved: 28.09.2009 Frithjof Raesch	Released: 28.09.2009 Frithjof Raesch

Visual Striation Rating Table Summary (OD grater than 13 mm)

Grade	Quality Level	Uniformly Distributed (ID or OD)	Individual / Discrete Lines (ID or OD)
1	High	Only faint striations visible. Can't be felt.	One or two individual striations or flow lines that appear to be heavier than the faint uniform striations. Can't be felt.
2	Standard 1	Readily visible striations. Still can't be felt.	One or more individual striations or flow lines that appear to be heavier than the faint uniform striations. Still can't be felt.
3	Standard 2	Readily visible striations. Can just barely feel.	One or more individual striations or flow lines that appear to be heavier than the faint uniform striations. Can just barely feel.
5	Reject	Many very readily visible striations. Can readily feel.	Several individual striations or flow lines that appear to be heavier than the faint uniform striations. Can readily feel.

Note: Above criteria is based on unaided visual inspection.

Inclusions

A: Enclosed Inclusions:

Definition:

Foreign matter wholly enclosed within the tube wall (over 0.3 mm).

Limits:

- Long length (> 300 mm): Coloured or black line – Max length of 25 mm.
- Short length: (≤ 300 mm): Coloured or black line – Max length of 1.0 mm.
- Individual inclusion (spot): Max 0.5 mm diameter.
- Cluster (3 or more individual inclusions where each inclusion passes individually):
 Long length (> 300 mm): Max of 2 clusters in any 300 mm of tubing length.
 Short length: (≤ 300 mm): Max of 1 cluster per tube.

B: ID Exposed Inclusions:

Definition:

Foreign matter apparently exposed to the bore surface (over 0.3 mm).

Limits:

None permitted.

C: OD Exposed Inclusions:

Definition:

Foreign matter exposed to the outside surface (over 0.3 mm).

	Product Specification RQ 235/245 for Lamp and General Application	SPEC_Z_LW_08 (Rev.1) page 7 of 9
Authors: 28.09.2009 Ludwig Stier Dr. Sigrun Rakus	Approved: 28.09.2009 Frithjof Raesch	Released: 28.09.2009 Frithjof Raesch

Limits:

- Individual inclusion (spot): Max 0.5 mm diameter.
- No more than 1 inclusion cluster in any 300 mm of tubing length.

Note on inclusion clusters (enclosed or OD):

Consider a cluster to be 3 or more individual inclusions with each inclusion within a millimetre of the next inclusion, with each inclusion visible to an unaided eye (> 0.3 mm), and with each individual inclusion passing the max size specification for an individual inclusion.

Dimensional Characteristics:

Standard Tubing – Tolerance guidelines

OD	Size Wall (as a % of nominal OD)	OD Tolerances (as a % of nominal OD)	Wall Tolerances (as a % of nominal Wall)	Siding Max (as a % of nominal Wall)	Ovality Max (as a % of nominal OD)	Bow Max (prorate to actual tube's length)
under 5 mm	≥ 18 % (thick wall)	± 2.5 %	± 10 %	10 %	2.0 %	2 / 1000 mm
5 to 6 mm	≥ 18 % (thick wall)	± 2.0 %	± 10 %	10 %	2.0 %	1.5 / 1000 mm
> 6 to 20 mm	≥ 18 % (thick wall)	± 1.5 %	± 10 %	10 %	2.0 %	1.5 / 1000 mm
under 6 mm	< 18 %	± 2.0 %	± 10 %	10 %	2.0 %	2 / 1000 mm
> 6 to 20 mm	< 18 %	± 1.25 %	± 8 %	8 %	2.0 %	1.5 / 1000 mm
> 20 to 40 mm	All	± 1.125 %	± 8 %	8 %	2.0 %	1.5 / 1000 mm
> 40 to 60 mm	All	± 1.125 %	± 10 %	10 %	2.0 %	1.5 / 1000 mm

Length Range Finished Cut	30 mm OD and under Length Tolerances	Over 30 mm OD Length Tolerances
Under 150 mm	± 0.5 mm	± 1.0 mm
150 up to 300 mm	± 0.75 mm	± 1.0 mm
300 up to 1000 mm	± 1.5 mm	± 1.5 mm
1000 up to 2000 mm	± 3 mm	± 3 mm
2000 and above	± 6 mm	± 6 mm

	Product Specification RQ 235/245 for Lamp and General Application	SPEC_Z_LW_08 (Rev.1) page 8 of 9
Authors: 28.09.2009 Ludwig Stier Dr. Sigrun Rakus	Approved: 28.09.2009 Frithjof Raesch	Released: 28.09.2009 Frithjof Raesch

Outside Diameter (OD)

Definition:

All diameters in all cross-sectional planes along length (“all points in”).

Inside Diameter (ID)

Definition:

Minor axis diameter at the tube ends (as measured by plug gages).
ID is not a criteria unless specifically given in print, order or standard.

Wall Thickness (WT)

Definition:

All wall thicknesses on the circumference of both ends.

Ovality

Definition:

Out of Round Diameter (circular run-out tolerance).
Expressed as a percent = $(\text{Max OD} - \text{Min OD}) / \text{Specified Nominal OD} \times 100 \%$
Expressed as an amount = $\text{Max OD} - \text{Min OD}$

Siding (Eccentric wall)

Definition:

Difference between greatest and least wall thickness, at either tube end.
Expressed as a percent = $(\text{Max Wall} - \text{Min Wall}) / \text{Specified Nominal Wall} \times 100 \%$
Expressed as an amount = $\text{Max Wall} - \text{Min Wall}$

Bow

Definition:

Amount of deviation to a straight edge, usually a curve.
Measurement = $\text{Max Gap to a Straight Surface} / \text{Length of Tube}$

Note: Bow is often specified as a maximum amount over a given length (such as per 1000 mm). The maximum deviation per tube is prorated for the actual length of the tube.

Cut Length

Definition:

All lengths, parallel to the centreline or any physical part of the tube.

Limits:

fc (Furnace Cut) standard spec: specified length +/- 10 mm.

	Product Specification RQ 235/245 for Lamp and General Application	SPEC_Z_LW_08 (Rev.1) page 9 of 9
Authors: 28.09.2009 Ludwig Stier Dr. Sigrun Rakus	Approved: 28.09.2009 Frithjof Raesch	Released: 28.09.2009 Frithjof Raesch

Cutting Irregularities

Definition:

Deviation from a smooth, perpendicular end cut.

-Step cut: Junction of two intersecting cutting planes.

-Slant cut: Not perpendicular.

-End Protrusion: Point on end.

-Chip: Piece of material missing from the OD/ID surface at the tube end.

Limits:

Refer to Raesch Specification "General Criteria for Cutting of Quartz Glass Tubes".

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Effective Documents:

Sortierkriterien RQ 235 for Lamp and General Application (RK_Z_LW_14)

Sortierkriterien RQ 245 for Lamp and General Application (RK_Z_LW_43)

Raesch Specification "General Criteria for Cutting of Quartz Glass Tubes"